

11498



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Order #
6F9540V00231
Job Sheet 192034



See this will need a Concussion by QC

Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: New

Job Created: 3/14/19

Job Tracking No:

Due Date: 5/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

POSITIVE RECALL

EFFECTIVE 12/23/14 AUTH SAD

RELEASED 55 DATE 31 MAY 2019
Priority: Medium

Bill of Materials

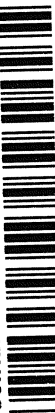
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs	5/1/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

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Container No: S171709



Part: 6F9540V00231

Job No: 192034

Serial No/Batch: S171709

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 04/11/19

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					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
105 QC 4	1 pcs	5/1/19	0.00 0.00		QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 69	DAS 69 9-89
					QC 4 - 9	
					QC 4 - 46	DAS 69 9-89
120 Packaging 3-1 - Stock - B4B	1 pcs	5/1/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
125 DC - 1 - B4B	1 pcs	5/1/19	0.00 0.00		DC - 1 - B4B	DAS 21 9-89
					DC - 2 - B4B	
130 QC 21 - FG	1 pcs	5/1/19	0.00 0.00		QC 21 - FG - 21	DAS 21 9-89
					QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 100 - (Pick Kit)

Descriptions: 105 - (QC4- 100% Inspect kits for completeness)

120 - Identify and pack for shipping as per PPP 6F9540V00231

125 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

130 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D169-841-015	AW169 Lower Cutter	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5141105
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	D169-841-015	1	1	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

		Supplier Concession				PAGE 1 of 2	PLANT Vergiate
Supplier NC N.	AWC-019/00	Date	14.05.2019	AW Concession	400000082381	Purchase Order	4801885188
P/N	6F9540V00231			Grade/Category	NC	Drawing Issue	
Part Description	PROTECTR, CCP ASSY LOWER			Batch Quantity	1,000	Defective Quantity	1,000
AW NC	MARCO FRANCESCONI					A/C Type/Model	AW6
Supplier	DART AEROSPACE LTD					Contract	
Defect MA01 - Items or materials different from requir - S/N S171709							
Cause of Defect				Repetitiveness (same P/N - Defect Code) NO ☐ YES ☒ (7)			
ENGINEERING Evaluation and Proposal							
Engineering Evaluations, including Specialist inputs:				Investigation Report n.		Compliance Report n.	
* 30.05.2019 17:11:44 MARCELLO STEFANELLI (9273) * The evaluation reported in the annex concession of the supplier are acceptable and applicable. The part can be installed with the repair instruction.							
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B							
Defect effect				Limitations			
	Before Repair		After Repair		☐ YES (to specificity) ☒ NO		
Safety	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Life or Duration	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Strenght	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Performances	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Interchangeability	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Reliability	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Maintainability	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Installability	☒ YES	☐ YES ☒ NO	☐ YES ☐ NO				
Testability	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Only Appearance	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
No Effect	☐ YES	☐ YES ☐ NO	☐ YES ☐ NO				
Repair Proposal:				Decision			
* 30.05.2019 17:11:44 MARCELLO STEFANELLI (9273) * See the proposal reported in the attached document of the supplier.				☐ Use rep. with spec.repair(not yet applied) ☒ Use repaired with known repair(yet applied) ☐ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification		☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO	
Mark part with Concession		☒ NO ☐ YES		Method :			
ATE	MARCELLO STEFANELLI		CPE			Date	30.05.2019
Checks and tests to be performed							
Repair registration		with repair WO ☒ Number:					
Repair Evaluation:							
Final Decision							
S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)
S171709	☐	☒	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
Not Serialized	Use As Is (Q.ty)	Use Repaired (Q.ty)	1,000	Scrap (Q.ty)			
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative	
Signature	MARCELLO STEFANELLI						
Date	30.05.2019						



Supplier Concession

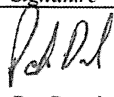
PAGE
2 of 2

PLANT
Vergiate

Supplier NC N.	AWC-019/00	Date	14.05.2019	AW	400000082381	Purchase Order	4801885188
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DEFECT CAUSES

- * C41 Material did not comply with specificati

		CONCESSION				Pag. 1 of 2	
Manuf. Doc. N.	AWC-019	Date	May 10, 2019	AW Doc. N.	_____	Purchase Order	4801885188
AW P/N	6F9540V00231	S/N / Batch Number	S171709	Grade	A	AW Drawing Issue	B
Description	Protector, CCP Lower Assembly			Batch Q.ty	1	Defective Q.ty	
Manufacturer	Dart Aerospace LTD			Model	AW169		
Defect(s) Description							
- Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 onto the Leonardo interface bracket - The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-16-9-89	 Pat Duval	May 10, 2019
Defect(s) Cause							
- The Lower Cutter body has a dimension of 0.43 +0.01/-0.00. This dimension was reported as part of the approved FAI and has been met with all delivered product - Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-16-9-89	 Pat Duval	May 10, 2019
Corrective Action						Complete Before	
- In order to mitigate the interference issue for Leonardo, Dart is proposing removing 0.010" (0.254 mm) from each face of the lower cutter body for a total gain of 0.020" (0.508 mm). - Dart Aerospace HBY requesting drawing update to allow for grain direction change on D4842-1							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-16-9-89	 Pat Duval	May 10, 2019

For "MANUFACTURER" SUPPLIERS ONLY

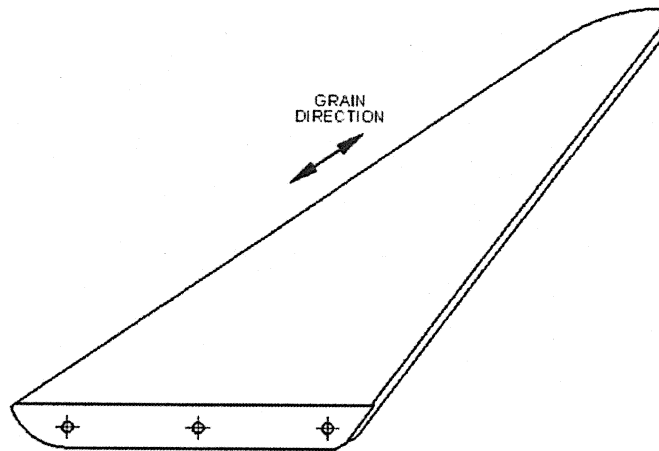
ENGINEERING evaluation and proposal

Engineering evaluation

Investigation report
Compliance report

n: NCR18-6764
n... N/A.....

1. Dart's position is that this change will not impact the structural substantiation presented in Report DA169-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.010" from each part will not impact the structural integrity of the lower cutter assembly. With the tolerance stack-up the lower cutter body would measure 0.84" (21.34 mm) to 0.88" (22.35 mm) which provides an additional 0.002" for variance of the sealant.
2. Grain direction was rotated 56° to align with the leading edge of the deflector. This orientation allows for a smaller raw material blank size and significantly reduce material scrap. The grain direction is still effectively perpendicular to the bending plane from cable loads. The effect on strength is insignificant.



	Defect effects		Limitations
	Before any repair	After any repair	
	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Safety	☐ yes	☐ yes ☐ no	
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal			Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☐ Scrap
Concession Classification	☒ Major ☐ Minor		Submit after repair ☐ yes ☐ no

		CONCESSION				Pag. 1 of 2	
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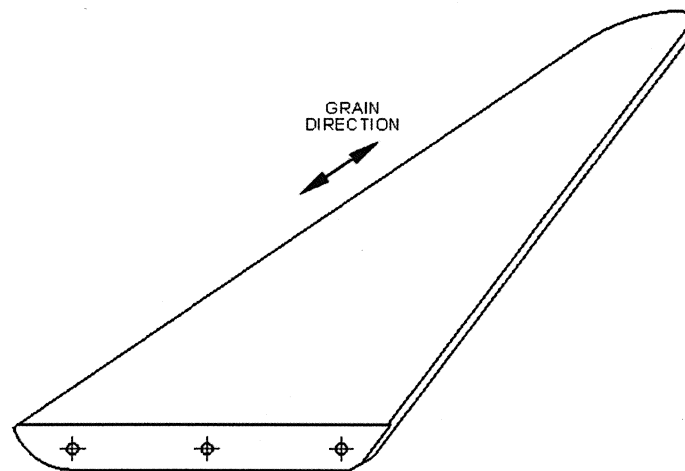
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